

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012656**Date Inspected:** 05-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW layered welding of SSD1-A683A/B located on PCMK south tower, skirt beam. Welders were identified as 070046, 070478. ZPMC QC was identified as CWI Du Zhi Qun (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QC Gao Zhi Chun. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on ZPMC repair order T-WR3082. Also present at this location and appearing to be monitoring the welding related operations were ABF Representative Zhang Huilong.

FCAW layered welding of ED1-A27 located on PCMK east tower, shear plate assembly. Welders were identified as 070101, 067500. ZPMC QC was identified as ZPMC CWI You Qi Guo (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was QC He Gen. The welding variables recorded by QC2's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair listed on ZPMC repair order T-WR3074. Also present at this location and appearing to be monitoring the welding related operations were ABF Representative Zhang Huilong.

Bay 11

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joint NSD1-SA4-68-143M-3, 5, 6, 8 located on PCMK north tower, lift 4, struts plate assembly, weld run-off tabs. Welders were identified as 046704. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-3211-TC-U5b-1, WPS-B-T-4111, WPS-B-T-4113, and WPS-B-T-4112-2.

Heavy Dock

This QA Inspector randomly observed no apparent work being performed on the heavy dock.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
